

Work Order ID 70734

Tuesday, June 14, 2011 9:22:47 AM



Page 1

Item ID: D2891-1

Accept



Setup Start



Revision ID: ~~U/R~~

Stop



Item Name: 2.25 Support

Start Date: 6/14/2011 Start Qty: 29.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 29.00



Customer:

Reference: Rework

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2891

Rev A1 U/R

OK

11.06.20 PSI 042

130

White Gloss(Ref:4.3.3.2) per QSI003 4.3 Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

PULL FROM STOCK:

9 X D2891-1 B53773 -

20 X D2891-1 B68522 -

STRIP PAINT COMPLETELY PER U/R FORM 11/06/13

25 11-06-17

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 06 17

Tuesday, June 14, 2011 9:22:47 AM

Page 2

[illegible]

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying up-to-date on new information and techniques.

9. The ninth step is to apply the knowledge. This involves using what you have learned to solve other problems.

10. The tenth step is to become a problem solver. This involves developing the skills and mindset to solve any problem that comes your way.

[illegible]

1. The first step is to identify the variables that are being measured. In this case, the variables are the number of hours spent on each activity (reading, writing, and thinking) and the total number of hours spent on all activities.

2. The second step is to determine the units of measurement for each variable. The units for the number of hours spent on each activity are hours, and the units for the total number of hours spent on all activities are also hours.

3. The third step is to collect data for each variable. This can be done by asking participants to report the number of hours they spent on each activity over a certain period of time.

4. The fourth step is to analyze the data. This can be done by calculating the mean, standard deviation, and other statistical measures for each variable.

5. The fifth step is to interpret the results. This can be done by comparing the results to previous studies and drawing conclusions about the relationship between the variables.

Customer:

[illegible]

PC (Y/N):

**Insp.
Stamp**

1. The first step in the process is to identify the problem. This involves gathering information about the situation and understanding the needs of the stakeholders involved.

2. Once the problem is identified, the next step is to develop a plan. This involves setting goals and determining the steps that need to be taken to achieve those goals.

3. The third step is to implement the plan. This involves putting the plan into action and monitoring progress.

4. The final step is to evaluate the results. This involves assessing the effectiveness of the plan and making adjustments as needed.

11 06 17

RE-IDENTIFY USING NEW B/N

[illegible]

11/6/2024

Wmf
11-06-27

Tuesday, June 14, 2011 9:22:45 AM

Page 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.



4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.



Required Qty: 29.00

Comments: IPP C 02.11.26 Added P/O KJ
IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2891-1		Manufactured	No				Each	0.0000		29			
 <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 10px;"> <div> <p>2.25 Support</p> <p>353 773 x 9</p> <p>B 68522 x 20</p> </div> <div>  </div> <div> <p>25 11-06-17</p> </div> </div>													

Under Review Notification

Raised By: Chris Provencal

Date: 11.06.13

Product #: 667, 676, and 664

Product Name: crosstubes

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2891-1	Support				Y	Y	N	Y	Y	Y	Y		
D2892-1	Support				Y	Y	N	Y	Y	Y	Y		
D2893-1	Support				Y	Y	N	Y	Y	Y	Y		
D2940-1	Support				Y	Y	N	Y	Y	Y	Y		
D212-664-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D412-664-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-143	Crosstube				Y	Y	N	Y	Y	Y	Y		
D407-667-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-243	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-676-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		

Description of issue:

- Process to bond supports onto crosstube is changing
- Finish on supports and xtube will change
- Get new process instructions from ENG prior to making more xtubes
- Modified crosstubes will need a new CHG number

Item ID	Item Name	Lot Qty	Lot Nbr
D2891-1	2.25 Support	9	53773
D2891-1	2.25 Support	20	68522
D2892-1	Support	14	42785
D2892-1	Support	14	68808
D2892-1	Support	2	70115
D2893-1	2.75 Support	15	69713
D2893-1	2.75 Support	5	69713
D2893-1	2.75 Support	1	68799
D2894-1	2.750 Support	4	66702
D2894-1	2.750 Support	4	43881
D2896-1	Support	11	67742
D2940-1	Support	20	68373
D2940-1	Support	1	60271

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Wednesday, June 15, 2011 3:05 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'; 'Linda Lacelle'
Subject: RE: Procedure for installing supports.

Hi Chris,

I agree with your procedure outlined below. It is our preference to leave the paint on the crosstube if we can for added corrosion protection (and for ease of manufacture). If Dan's final testing shows there is a big difference between a painted/unpainted crosstube, then we will switch to alodine only on the crosstube.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 15, 2011 11:24 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

David,

Can I confirm that this is the agreed procedure for all newly manufactured tubes with off-center supports:

- Scuff paint under support, clean with MEK
- Completely remove any finish on support (if present), scuff bottom surface of support, clean with MEK
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Let cure for 72 hours after installation, recheck torque.

Chris

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Tuesday, June 14, 2011 10:59 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

Made a couple of small changes.

- Remove finish on xtube in area of support down to alodine finish.
- Touch up alodine on xtube in affected area
- Completely remove any finish on support, scuff bottom surface of support
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Touch up paint finish as req'd per QSI 005
- Let cure for 72 hours after installation, recheck torque.